



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D135-1027-143
Job Sheet 170185

Accounting Job RD17-1027-01



Part No: D135-1027-143

Job Qty: 1 ea

Part Name: MID HEIGHT FWD Crosstube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 1/11/18

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: R+D

Description:

Note: D135-1027-143 REV.A IPP REV:A 17.09.08 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/18/18	0.00	0.00	Start Up Container		
100	HandFinish	1 pcs		1/18/18	0.00	0.25	HandFinish1		
110	QC	1 pcs		1/18/18	0.00	0.00	QC7-1		APR 26 2018
120	HandFinish	1 pcs		1/18/18	0.00	0.25	HandFinish4		APR 26 2018
130	QC	1 pcs		1/18/18	0.00	0.00	QC5		
140	SprayPaint	1 pcs		1/19/18	0.00	1.00	Spray Paint		APR 27 2018
150	QC	1 pcs		1/19/18	0.00	0.00	QC14		
170	Packaging	1 pcs		1/19/18	0.00	0.00	Packaging3-1	LGCSC	MAY 02 2018
180	QC21-SA	1 Ea		1/19/18	0.00	0.00	QC21		MAY 07 2018

Part Op 100 - ***PRIOR TO CHEMICAL CONVERSION*** SCRIBE DART P/N AND B/N ON INSIDE OF CUFF PER QSI 044 6.4
Descriptions: 120 - INSTALL THREADED ROD AS PER DWG AND APPLY LOCKTITE 263 (NOTE 9) AND SEAL BETWEEN THE
NUT AND CROSSTUBE USING SEALANT(NOTE10) *locktite 138857* *Proseal 138784 exp 9/18*
140 - ***MASK PRIOR TO PRIME AND PAINT AS PER NOTE11, BOTH ENDS*** 1- PRIME INSIDE AND OUTSIDE
PER QSI005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: *138408* 2- PAINT OUTSIDE SURFACE AS
PER QSI005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: *138819* 3- COAT INSIDE SURFACE WITH LPS
N/A *Procyon* AS PER DWG, QSI005 4.8 4- AFTER FINISH APPLY A 1 INCH CENTER LINE ON TOP OF CROSSTUBE
WITHIN 0.1" OF CENTERLINE QSI 044 6.1(SEE NOTE 12 AND 13)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D135-1027-153	<i>15053496</i>	0	0	0
	D5511-1	<i>166507</i>	7	0	0
	MS35650-304	<i>FMI37878</i>	60	0	0
	NAS1149D0363J	<i>5015269</i>	4,315	0	0

Part Specifications



Container No: S066293

Part: D135-1027-143

Job No: 170185

Serial No/Batch: S066293

Revision: A
Inspector:



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

1/11/18 10:22 AM dart.poulin.mario

P.T.O.

nm 19 Jun 2019

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐



Work Order: <u>170185</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D135-1027-143</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐					
NCR No. <u>19-7179</u>		Suspected Unapproved ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐					
Date: <u>16/5/2</u>		Step #: <u>140</u>		QTY Effective: <u>1</u>					
Description Work Order Deviation		Disposition							
Dug cells for Procyon on inside surface of crashtube.		Not required. Difficult to apply and process not done on other crashtubes. Dug will be revised to remove procyon before <u>STE</u> approval <u>AR</u> MAY 02 2019							
Root Cause		Completed By <u>DAS 12 18/5/2</u> Lead hand / Supervisor Approval Verification <u>DAS 9</u> QC/QA Coordinator Approval <u>1805-17</u> <u>9-89</u>							
Environment ☐ Design ☒ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☒ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER: ☐									